









Work Order ID 67374

Thursday, March 17, 2011 7:30:35 AM

Page 1

Item ID:	D4035-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Lid Rib Assembly, Fwd (350 Basket)					
Start Date:	3/17/2011	Start Qty:	2.00		Cust Item ID:	
Required Date:	3/24/2011	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	11-03-17	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4035	A

100 Weld per dwg A/R S.S. rod Batch: 4114649 0.00



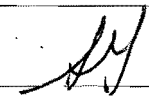
Large Fab

Large Fab

Memo 0.00

- 1- Cut D4035-1 as per dwg D4035
- 2- Drill as per dwg D4035 using DT9562
- 3- remove identification marks and deburr
- 4- Weld bushing in rib as per dwg D4035

SAO 11-03-18

2  11.03.21 (Gx)

110




QC

Quality Control

QC9- Inspect visual per QS1004- Fusion Welds 0.00

Memo 0.00

 11.03.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

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Page 2

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
130 Packaging Packaging	Identify as per dwg & Stock Location: Basket cell Memo	0.00 0.00							
140 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

11-03-22

11/3/23

MUF
11-03-22

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Picklist Print

Thursday, March 17, 2011 7:30:55 AM

Page 1

Work Order ID: 67374

Parent Item: D4035-041

Parent Item Name: Lid Rib Assembly, Fwd (350 Basket)

Start Date: 3/17/2011

Required Date: 3/24/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: new issue DD 09.11.25 verified by:EC
per dwg revA 10.03.15 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2327-3 Manufactured No



Spacer Bushing

100 Each 31.0000

1

2



Handwritten signature

11-03-21

Location

Loc Qty

Loc Code

WA005

31

58974

1

64920

2

66087

8

66535

20

(6x)

M304TS0.750W.049

Purchased

No

100

f

224.8708

1.75

3.684211



304 SQ Tube .75x.75x.049W



Handwritten signature

11-03-18

Location

Loc Qty

Loc Code

MAT018

224.8707578

114298

3.6845E-05

114323

8.15031894

114677

0.00001

114835

0.000039

114992

8.8798

115260

9.1239

116319

7.2604

116509

12.4739

116719

2.418053

116788

23.2148

117029

153.3495

Handwritten: BWD Bar
Scrap

Handwritten calculations:
1.8421 + 0.5760 = 2.4181
9.21075 + 1.000 = 10.21075

Handwritten: total = 12.8289

Handwritten: 11.0529
.576
12.6289

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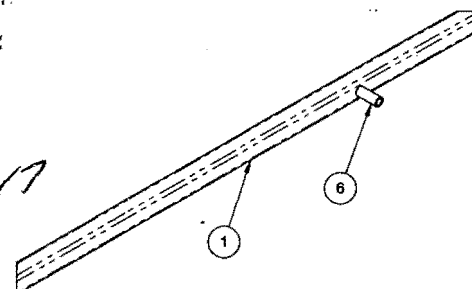
NOTE: Date & initial all entries

SHOP COPY

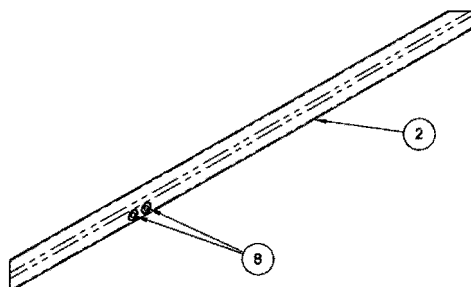
RETURN TO 4

ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 67374
PLH-03-17

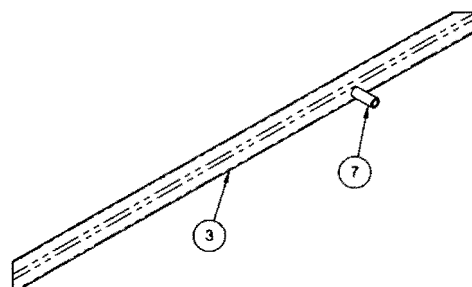
ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
	X				D4035-041	LID RIB ASSY, FWD
		X			D4035-043	LID RIB ASSY, AFT
			X		D4035-045	LID RIB ASSY, FWD (LIGHT)
				X	D4035-047	LID RIB ASSY, AFT (LIGHT)
1	1				D4035-1	RIB
2		1			D4035-3	RIB
3			1		D4035-5	RIB
4				1	D4035-7	RIB
5				2	D4035-11	BUSHING
6	1				D2327-3	SPACER BUSHING
7			1		D2953-175	SPACER
8		2			D4021-9	BUSHING



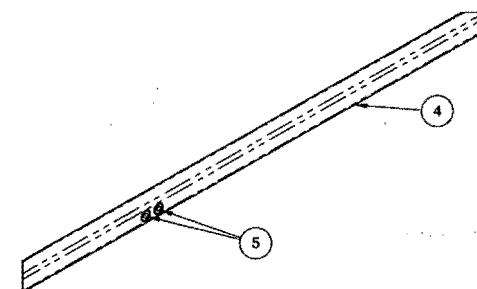
D4035-041 BASKET LID RIB ASSY, FWD



D4035-043 BASKET LID RIB ASSY, AFT



D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)



D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)

RELEASED
2010-03-12
AW

A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4035 TITLE BASKET LID RIB ASSY SCALE NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	JPH		
CHECKED	AJS		
MFG. APPR.	AJS		
APPROVED	AJS		
DE APPR.	AJS	REV. A	SHEET 1 OF 5
DATE	10.03.04		

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D



D4035-1
RIB

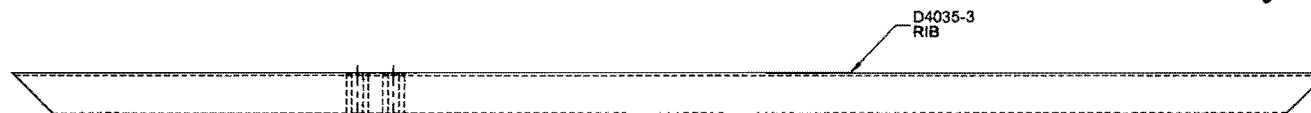
D2327-3
SPACER BUSHING

D4035-041 BASKET LID RIB ASSY, FWD

u/o 67374

C

C



D4035-3
RIB

D4021-9
BUSHING
2 PL

G
G
TYP

D4035-043 BASKET LID RIB ASSY, AFT

RELEASED
2010-03-12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.83 lbs
- 8) WELDING: PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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DE APPR.		BASKET LID RIB ASSY	NTS
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8 7 6 5 4 3 2 1

A

A

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8 7 6 5 4 3 2 1

D4035-5
RIB

D2953-175
SPACER

0.94

D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)

w/0 67374

D4035-7
RIB

D4035-11
BUSHING
2 PL

TYP

D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)

RELEASED
2010-03-12
AW

- NOTES:**
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.34 lbs
 8) WELDING: PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4035	SHEET 3 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET LID RIB ASSY	NTS
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8 7 6 5 4 3 2 1

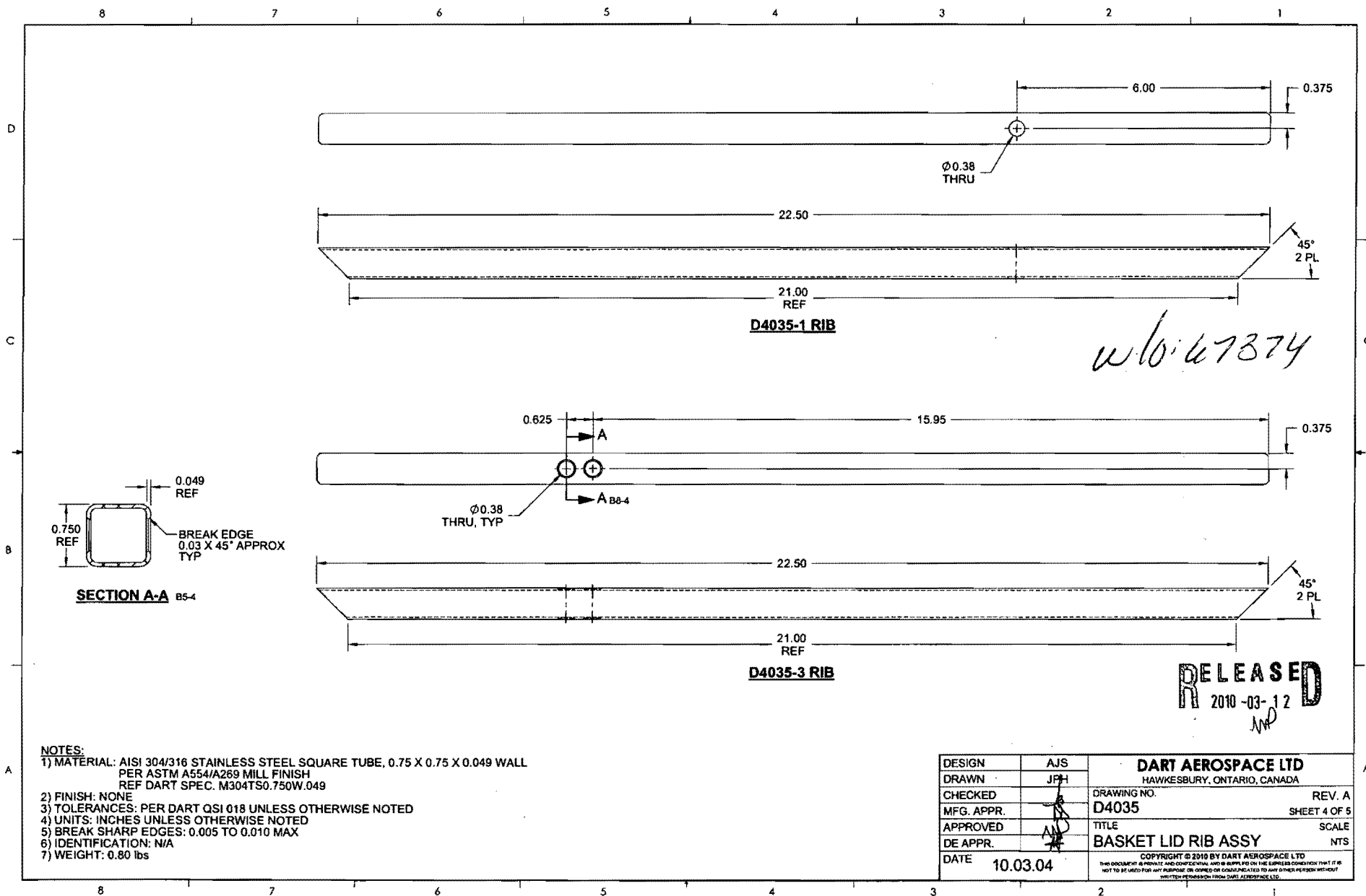
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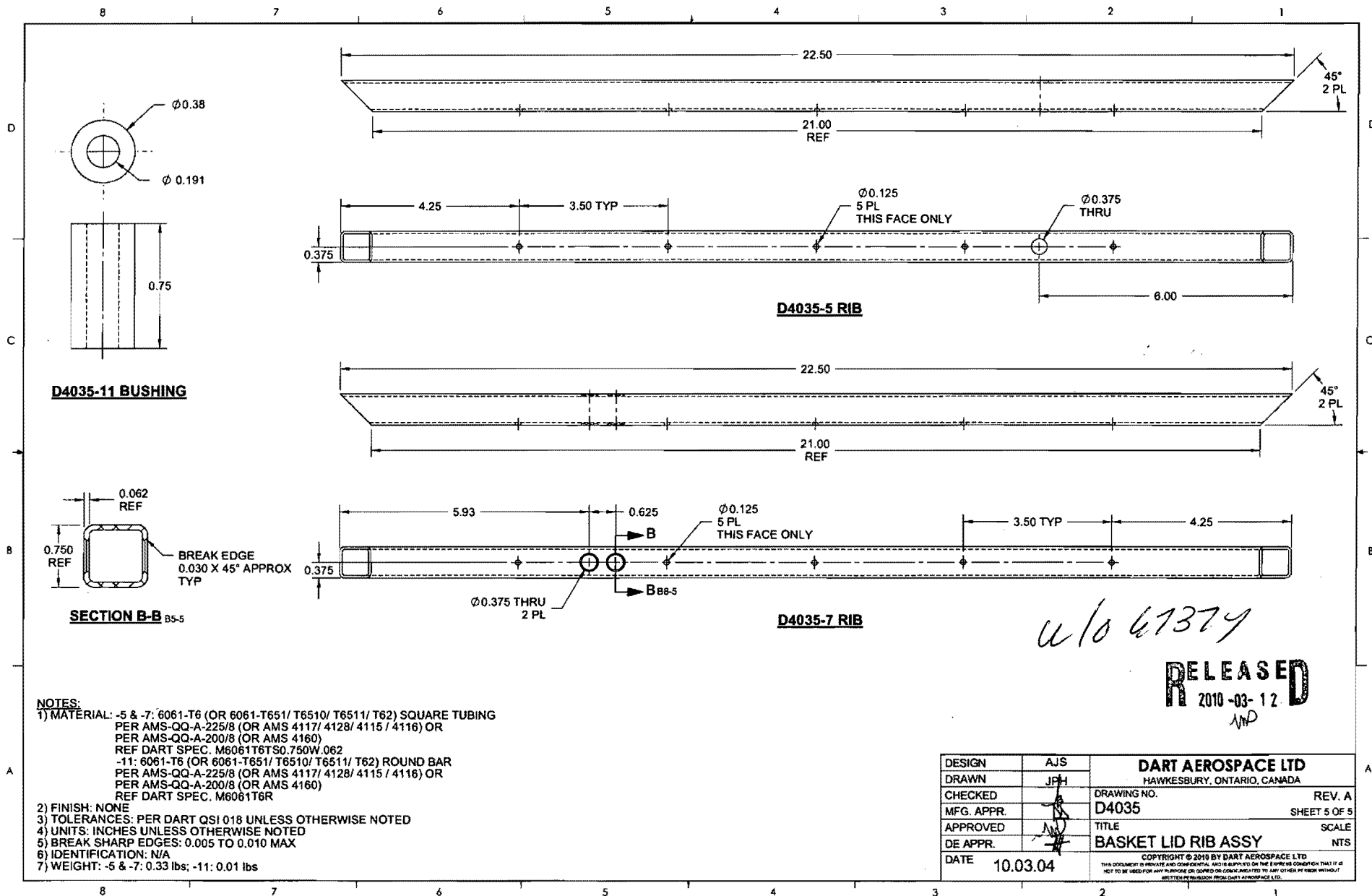
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